



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-024
Job Sheet 201245



Part No: D350-636-024

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4168-052 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Lead Time	
110	Skidtubes - 1	1 pcs	10/31/19		0.00	4.78 1:50TF	Skidtubes - 1	TF JF
							Skidtubes - 2	
							Skidtubes - 3	
							Skidtubes - 4	
							Skidtubes - 5	
							Skidtubes - 6	
							Skidtubes - 7	
120	QC 10	1 pcs	10/31/19		0.00	0.00	QC 10 - 10	DAS OCT 21 2019
							QC 10 - 18	
							QC 10 - 24	
							QC 10 - 43	
							QC 10 - 50	
							QC 10 - 58	
							QC 10 - 9	
130	QC 5	1 pcs	10/31/19		0.00	0.00	QC 5 - 10	DAS OCT 21 2019
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	

Plex 9/27/19 1:33 PM Dart.lajeunesse.marie

140 Handfinish - 1-1 Chemical-B4B	1 pcs	10/31/19	0.00 0.98	QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	A OCT 2 2 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	10/31/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	Mba
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	

					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
160 Skidtubes - 2 - B4B	1 pcs	10/31/19	0.00 4.78	1:15m TF	Skidtubes - 1 - B4B	ON
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
170 QC 10	1 pcs	10/31/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
180 QC 5	1 pcs	10/31/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/31/19	0.00 0.98		Handfinish - 2 - 1 - B4B	BE 19-11-18
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	10/31/19	0.00 0.61		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-11-19
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
210 QC 14	1 pcs	10/31/19	0.00 0.00		QC 14 - 15	HL 19-11-22
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	

230 Handfinish - 4-1-Assembly-B4B	1 pcs	10/31/19	0.00 0.98	QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				Handfinish - 4 - 1 - B4B	2019-11-22
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
240 QC 5	1 pcs	10/31/19	0.00 0.00	Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS NOV 25 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	10/31/19	0.00 0.00	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260	QC 4	1	10/31/19	0.00 0.00	QC 4 - 28
		pcs			QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
270	Packaging 3-1 - Stock - B4B	1	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B

DAS
78
8-89

JAN 06 2020

DAS
78
8-89

JAN 06 2020

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	10/31/19	0.00 0.00	DC - 1 - B4B	0.25
	pcs			DC - 2 - B4B	0.25
280 QC 21 - FG	1	10/31/19	0.00 0.00	QC 21 - FG - 21	0.25
	pcs			QC 21 - FG - 70	0.25
				QC 21 - FG - 53	0.25

JAN 06 2020

JAN 06 2020

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-6 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 (D4168-6 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DK-DK and open to 0.500" 5- Drill tow ring hole using DT9616 detail "DF" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail DF to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011
 9- Grind welds flush as per Dwg D4168
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 150 - (QC7- Inspect Chemical Conversion Coat)
 160 - 1-Open up holes using hole saw of Detail DG and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 4-Chamfer holes of Detail DG, ground handling and float holes per dwg D4168 (welding instructions on sheet) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5200625 exp. date: 072520 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 & QSI004 (welding instructions on sheet) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section ES-ES (total of 4 places per side) as per dwg D4168 12- C'bore section ET-ET. ADJUST TOOLING AS REQUIRED. VERF BY: 5137650 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****
 *****REF TO W/O BATCH: *****
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5291052
 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 230 - 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5200625 EXP DATE: 20-7-27 5- Coat all exposed fasteners with "LPS Procyon" batch: 5137650
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A
 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
 270 - Identify and pack for shipping as per PPPD350-636-024 Location : FG071
 275 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-024 CHG 001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1	013078
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5216212
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5187776
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5221693
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214194
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	51139009
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5217772
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5212331
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5217144
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5219776
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5202645
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5236837
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192242
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5208863
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5180740
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5225325
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5215506-1
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5225629
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5214976
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5216012-3
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5217965
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184404
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5210551
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215506
				5164718

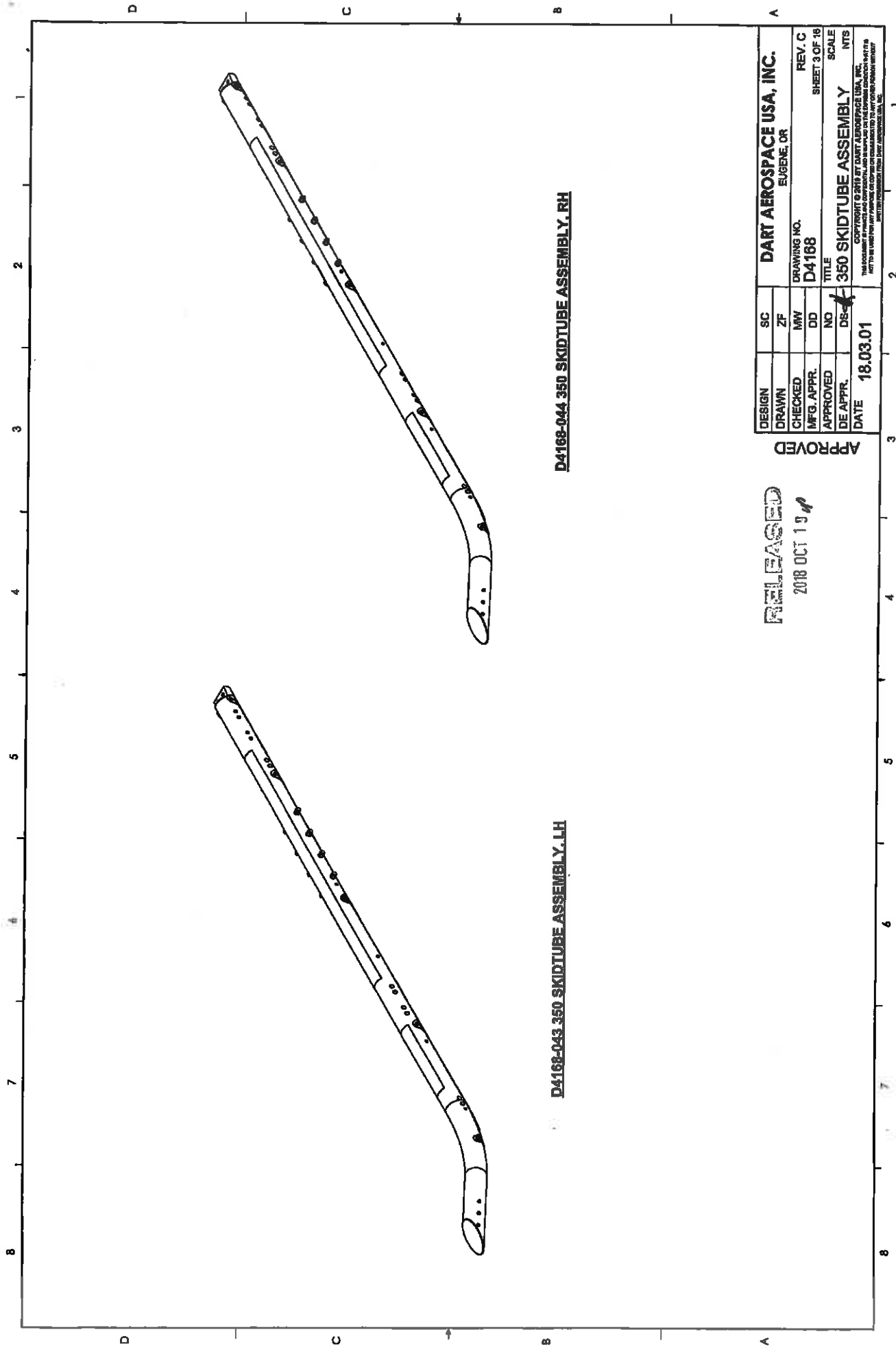
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	20	0
	D2744	1	34	0
160-Skidtubes - 2 - B4B	D2739	1	4	0
	D2743	8	369	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	1,716	0
	AN3C34A	1	32	0
	AN3C36A	4	186	0
	AN3C6A	4	150	0
	AN6C44A	4	86	0
	AN8C35A	1	9	0
	D2745	8	56	0
	D3488-4	1	24	0
	D3631-1	8	208	0
	D3873-1	7	137	0
	D4154-041	1	6	0
	D4170-1	4	121	0
	D4171-1	1	20	0
	MS21043-3	5	988	0
	MS21043-6	4	124	0
	MS21083C8	1	125	0
	NAS1149C0332R	4	2,485	0
	NAS1149C0363R	9	540	0
	NAS1149C0832R	1	262	0
	NAS1515H3L	4	223	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	76	0
	AN8C21A	2	67	0
	D2741	1	58	0
	MS21083C8	2	125	0
	NAS1149D0863J	2	311	0

Part Specifications

Specifications could not be found.

Plex 9/27/19 1:33 PM Dart.lajeunesse.marie



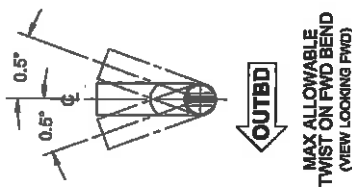
D4168-044 350 SKIDTUBE ASSEMBLY, RH

D4168-043 350 SKIDTUBE ASSEMBLY, LH

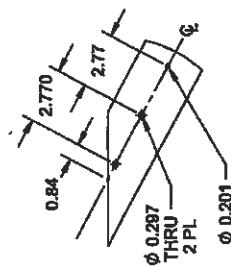
RELEASED
2018 OCT 19

DESIGN		SC	DART AEROSPACE USA, INC.	
DRAWN		ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO. D4168		
MFG. APPR.	DD	REV. C		
APPROVED	NO	SHEET 3 OF 18		
DE APPR.	DS	TITLE 350 SKIDTUBE ASSEMBLY		
DATE	18.03.01	SCALE NTS		

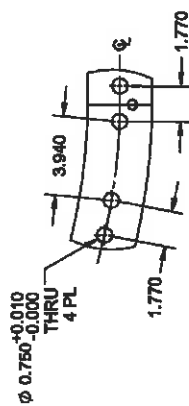
COPYRIGHT © 2018 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED OR DISSEMINATED
WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.



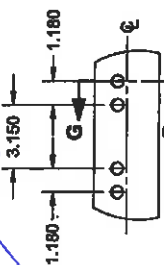
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**



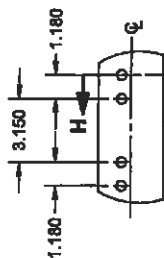
D7-5
DETAIL A
SCALE 2X



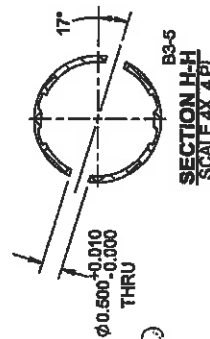
C7-
DETAIL B
SCALE 3/8"



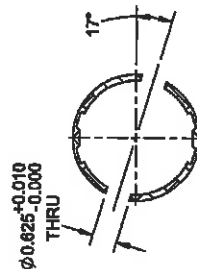
D5-5
DETAIL C
SCALE 2X



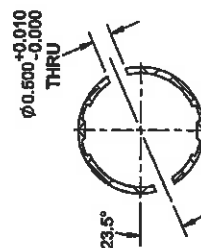
D3-5
DETAIL D
SCALE 2X



SECTION H-H
SCALE 4X 4 ft



B4-5
SECTION G-G
SCALE 4X, 4 PL



D6-5
SECTION E-E
SCALE 4X, 2 PL

DESIGN	SC
DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS- 1
DATE	18.03.01

DART AEROSPACE USA, INC.
EUGENE, OR

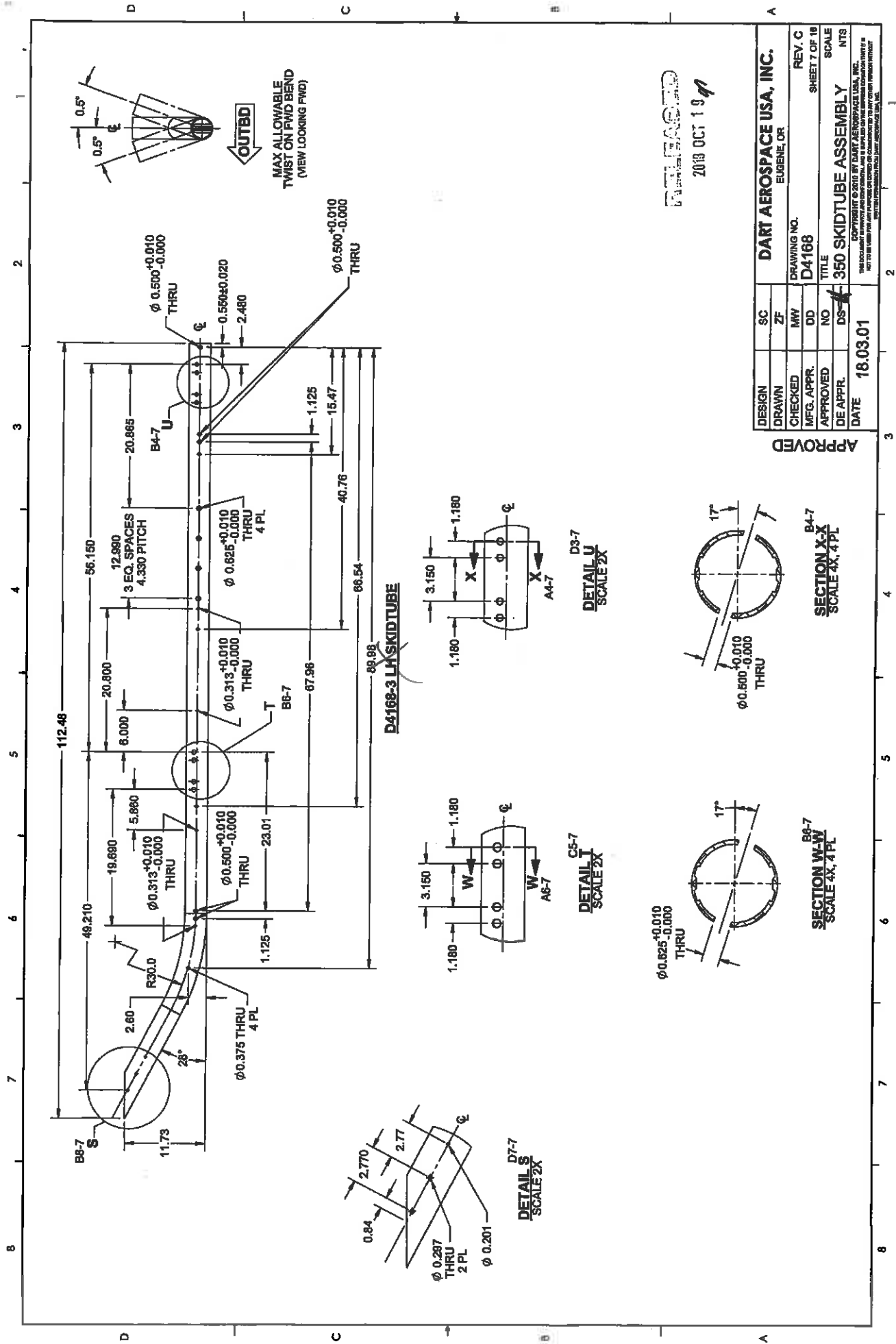
DRAWING NO.

1168

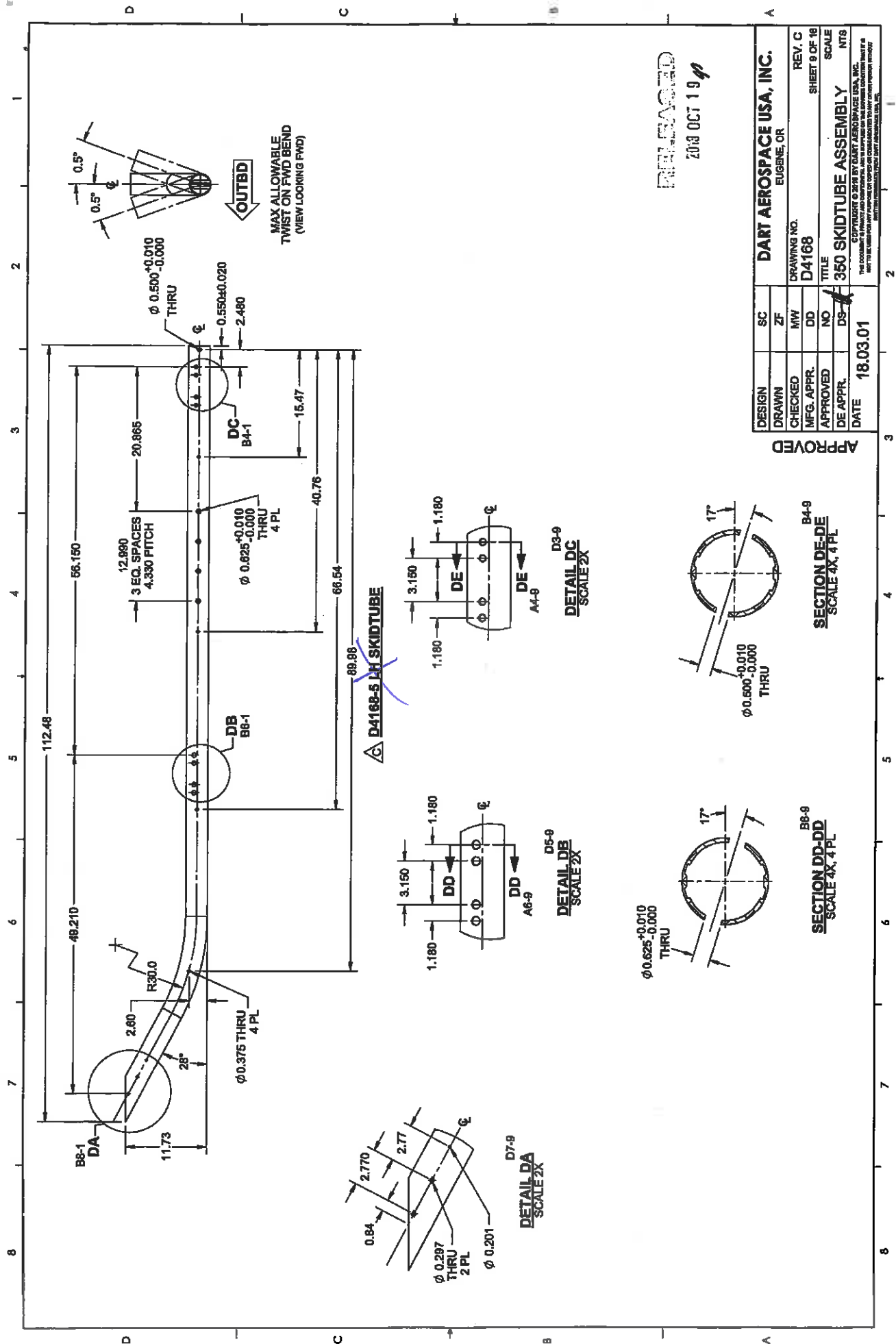
3

COPIES OF

NO REVENUE FOR JUNE



2018 OCT 19



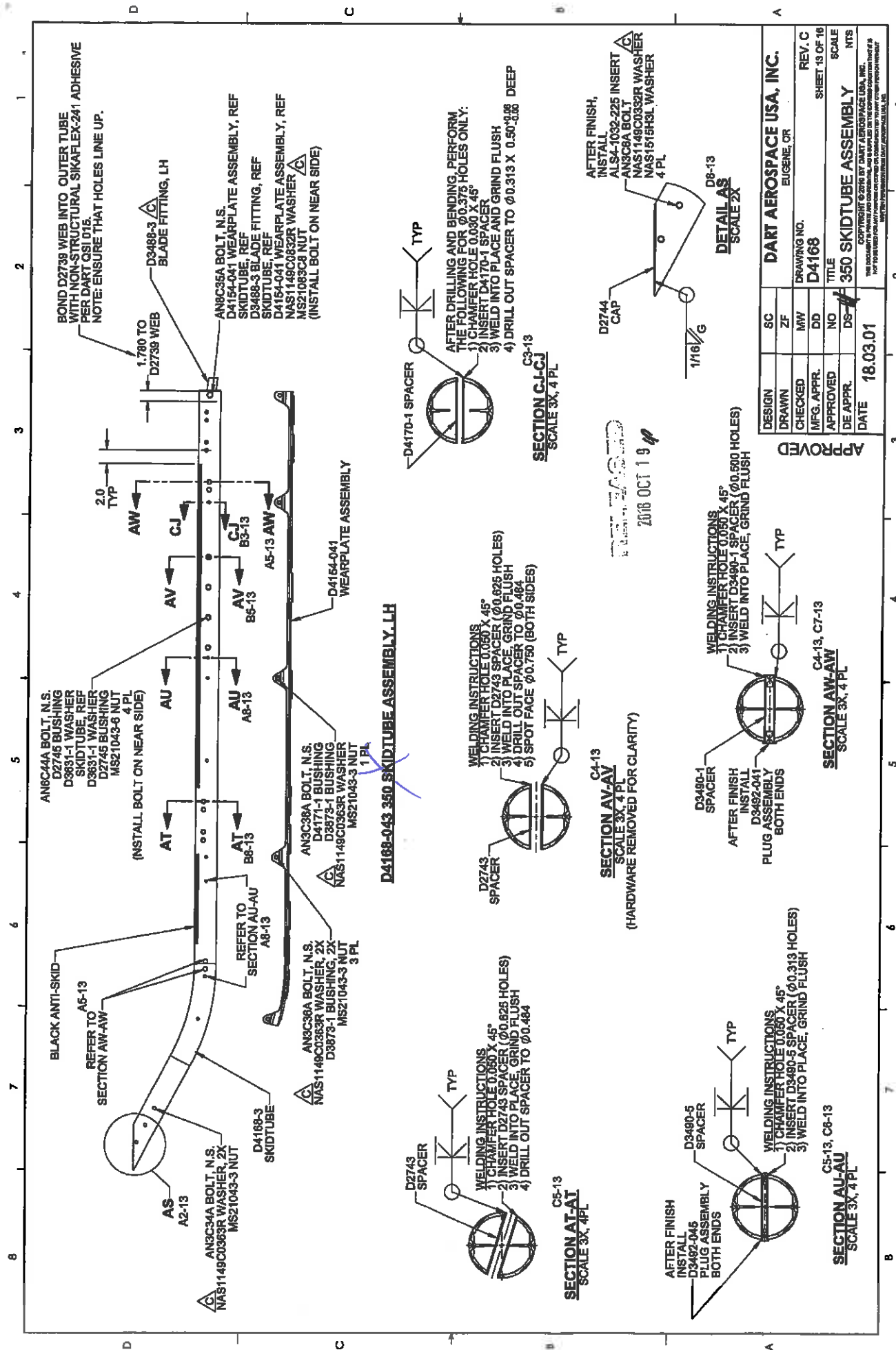
RELEASED
2018 OCT 19

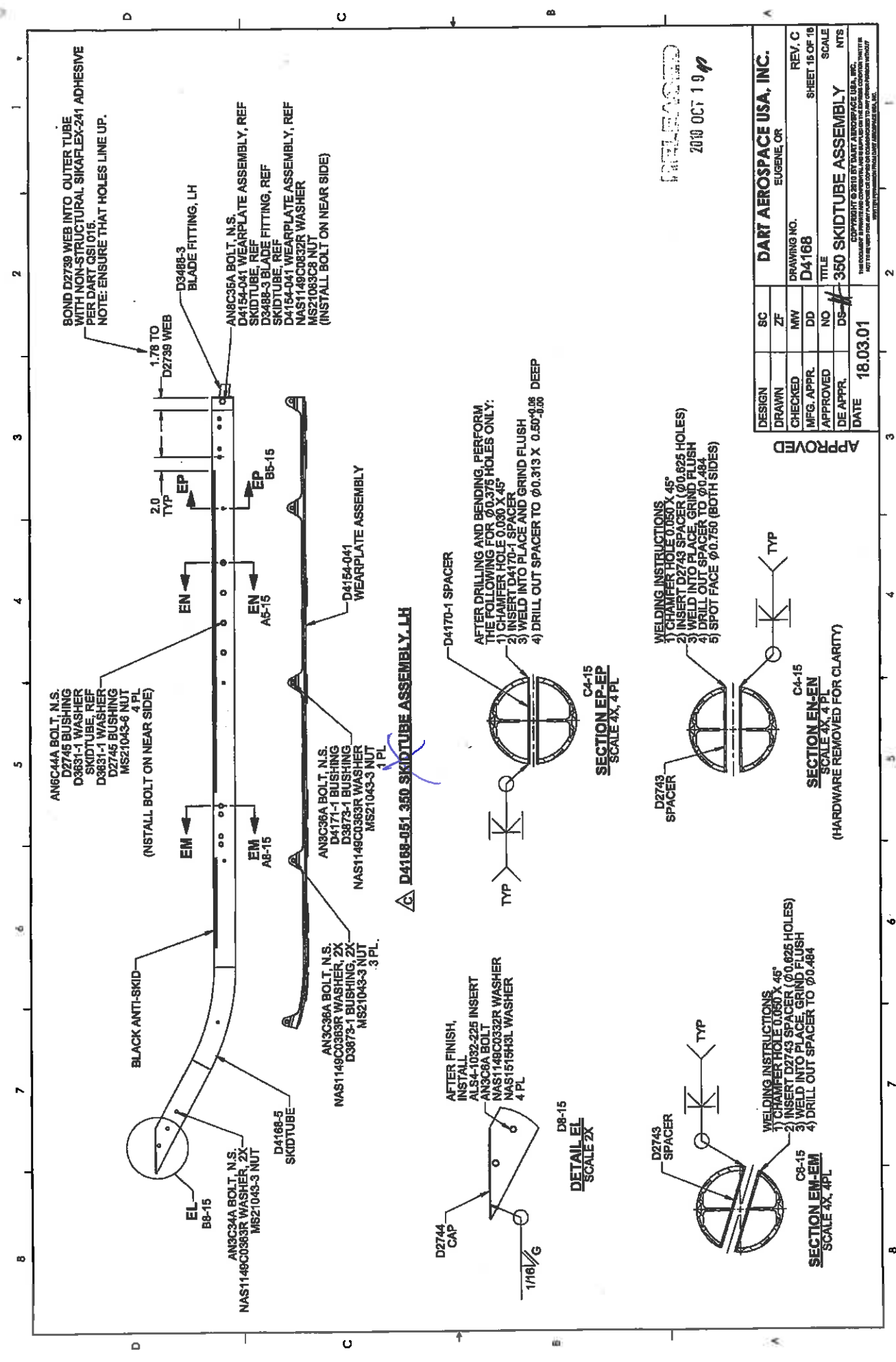
DART AEROSPACE USA, INC.					REV. C	
DESIGN	SC	ZF	MW	DD	SHEET 8 OF 18	
DRAWN					D4168	
CHECKED					TITLE	
MFG. APPR.					350 SKIDTUBE ASSEMBLY	
DE APPR.					SCALE	
DATE					NTS	
					18.03.01	

B4-9
SECTION DE-DE
SCALE 4X, 4 PL

B8-9
SECTION DD-DD
SCALE 4X, 4 PL

COPYRIGHT © 2018 BY DART AEROSPACE USA, INC.
ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.





BOND D2739 WEB INTO OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 016.
NOTE: ENSURE THAT HOLES LINE UP.

1.78 TO
D2739 WEB

2.0
TYP

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

EP

BB-15

EN

EN

EM

EM

BB-15

EP

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QSI042) ☐																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																																					
Description Work Order Deviation						Completed By																																					
						Lead hand / Supervisor																																					
						QC / QA Coordinator																																					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>										Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																								
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																								
Crushing	BOM/Route	Grain Direction	Drawing																																								
Cracks	Broken/Damage/Defect	Weld	Finish																																								
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																																								
Marks/Chatter	Drill Holes	Out of Sequence	Misread																																								
Mislabeled	Fit/Function	Off-set/Set-up																																									
						Other/Details:																																					

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCROISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCROISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1			D2741	BLADE
10	2	2	2	2	2	2		AN3C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **K**
Date: 18.04.04

Change Record

Part Number: D350-636-023/-024

PAGE 1 OF 1

Description: SKIDTUBE INSTALLATION LH/FH, STD COMPATIBLE W/TRAINING WEARPLATI

[illegible]